	Work Order ID 84917 May-29-12 1:09:11 PM			*84917*								
Revision ID:	D209-669-014 Skidtube RH			Accept	*N900	1 040	100)*	Setup	Start Stop	1 🕠	S1* S2*
Start Date:		Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer						I VI	
Approvals:	Process Plan:	MLJ	Date: 12/05/	D Tooling:		Date:			Run	Start	*N	R1*
	QC:	·	Date:	_ SPC (Y/N):		Date:				Stop	*N	R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
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D209-669-014 DSI 9450	Rev B Rev A		\bigcap	2 A?)	1.							
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Work Order ID: 84917

Parent Item Name: Skidtube RH

84917

Parent Item:

D209-669-014

D209-669-014

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

New IPP 08.02.13 new issue EC, verified by:DD IPP Rev:B 08-05-20 chg QTY of D2570 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Statu Issued
-D209-669-043		Manufactured	No			110	Each	2.0000	1	1 .		
D209-669	9-043								**	840	F94	1
רא'				Location	<u>1</u>	<u>Loc</u>	<u>Qtv</u>	Loc Code			,	
				Mezz			2				_	
					39205		1				-	
D2017.2					39206		1		_			\wedge
D2917-2		Manufactured	No			110	Each	1.0000	2	2		_ []
D2917-2 Saddle RH	•								** 3	18493	9	24 '
				Location	<u>1</u>	Loc	<u>Qty</u>	Loc Code				
				ST424			1					
					52129		1				=	\wedge
D2918-2		Manufactured	No			110	Each	1.0000	2	2		0// -
D2918-2	,								** 7	1948	10	30 %
				Location	1	Loc	Qty	Loc Code				
				ST424			1					
					52133		1				=	

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DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval				
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date		ion C	Chief Eng	QC Inspector				
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Work Order ID: 84917 Parent Item: D209-669-014 Parent Item Name: Skidtube RH			4917* 209-669-0	14*			: 29/05/2012	Required Date: 16/07/2012
						Start Qty	: 1.00	Required Qty: 1.00
*AN4-51A *Bolt	Purchased	No		110	Each	302.0000 8 **	8	
			Location 362 121181 ST361 119798 121584	<u>L</u>	200 200 200 102 30 72	Loc Code	8	- - - -
D2570 *D2570* Bushing	Manufactured	No	.2.00	110	Each	711.0000 24 **	24	sQ
•			Location ST011 72960 78586 79493 81956 81957	<u>L</u>	711 41 9 12 24 400 225	Loc Code	24	- - - - -
*MS210421.4 *MS210421 4*	Purchased	No		110	Each	4,095.000 24	24	N 12/4/13
			Location ST300 119075 121011 121444 121652	<u>L</u>	4095 125 713 2957 300	Loc Code	24	- - - -

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DATE	DATE STEP		Description of NC			tion B	Verific	cation	Approval	Approval
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Work Order ID: 84917		*8	4917*	-						
Parent Item: D209-669-014 Parent Item Name: Skidtube RH			0209-669-	014*			art Date: 2	29/05/2012	Required Date Required Qty	
AN5-36A	Purchased	No		110	Each	184.0000	4 **	4 <u>ح</u>	J.	
			Location 340 121181 121652 ST340 121708	<u>Lo</u>	134 34 100 50 50	Loc Code				
*AN960JD516 NAS1149D0563 *AN960.ID516* Washer	Purchased	No		110	Each	0.0000	8 **	8		954650
MS21042L5 *MS21042I 5* Nut	Purchased	No		110	Each	1,447.000	4 **	4	Or	
			Location 300 121652 ST300 108827 116105 116548 117611 119109 17651	<u>Lo</u> .	500 500 947 8 5 43 18 865 8	<u>Loc Code</u>		4		
[/] AN4-7A ⇒ *AN4-7A* Bolt	Purchased	No		110	Each	124.0000	16 **	16 M/2	22/4/	12/7/13/
			<u>Location</u> ST356 117514 120770	Loc	24 100	Loc Code			_ _	G
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Work Order ID: 84917 Parent Item: D209-669-014 Parent Item Name: Skidtube RH	·		4917* 209-669-0)14*			tart Date: 29		Required Date: 1 Required Qty: 1	_
AN960JD416 NAS1149D0463.	J Purchased	No		110	Each	30.0000	32	32		4
AN960.ID416							**		Mla	191254
			Location ST351 116289 119097	<u>Lo</u>	30 10 20	Loc Code				
*D2929 *D2929* Spacer	Manufactured	No		110	Each	86.0000	2 **	2		
			Location	Lo	c Qty	Loc Code				
D2930 P*D2930* Spacer	Manufactured	No	ST021 53564	110	86 86 Each	102.0000	2 **	2	- - - -	1
•			<u>Location</u>	Lo	c Qty	Loc Code				
103405-041 *D3405-041* Lug Assembly	Manufactured	No	ST021 53563	110	102 102 Each	6.0000	1 **	Z 1 85	5098	

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								tart Qty: 1		Required Qty: 1.00	4
AN4C47A	Purchased	No			110	Each	48.0000	4	4		<i> </i>
AN4C47A								**	M	12220451	
Soli			Location		Lo	oc Oty	Loc Code	•			
			ST361			48				_	
				8451		6	,			_	
				9798		2			***	-	
/				1009 1585		22 18					
MS21043-4	Purchased	No	12	.1363	110	Each	1,346.000	5	5	_	0
>*MS21043-4*								**		r	V/
Nut			Location		Lo	c Qty	Loc Code				
			FG			40					
			10	4603		40				_	
			ST301			1306					
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			12	1162 1652		659			_2	_	
D3405-043	Manufactured	No	12	1652	110	500 Each	2 0000			_	, ^
/	Manufactured	INO			110	Each	2.0000		1	n la	.1, 1
D3405-043								** (}	88494	101-	1162
			Location		Lo	c Otv	Loc Code				

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Work Order ID: 84917 Parent Item: D209-669-014 Parent Item Name: Skidtube RH	·	*849 *D20	917* 09-669-0	714*			tart Date:	29/05/2012 1.00	Required Dat Required Qt	te: 16/07/2012 y: 1.00
D3407-041 *D3407-041* Tow Ring	Manufactured	No		110	Each	27.0000	**	86	672	4
D3456-1 *D3456-1* Washer	Manufactured	_	ocation T463 82067 82068 82108	<u>Lo</u> 110	27 6 19 2 Each	<u>Loc Code</u> 156.0000	¦ **	1	S	
		F	25701 T044 80252 81876 83584	<u>Lo</u>	7 7 149 1 48 100	<u>Loc Code</u>			- - -	
D3417-5 D*D3417-5* Washer	Manufactured	No		110	Each	78.0000	2 **	2		2/7/1324

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B

INSTRUCTIONS:

- 1) FOR D209-669-011/-012/-013/-014 SKID TUBES @ CHANGE 003 AND SUBSEQUENT, MODIFY THE FOLLOWING:
 - a) REPLACE THE D2968-041 TOW RING WITH THE D3407-041 TOW RING ASSEMBLY.
 - b) REPLACE THE D2736-1 AND D2736-3 GHW LUGS WITH THE D3405-041 AND D3405-043 LUG ASSEMBLIES.
 - c) AMEND THE PARTS LIST IN SECTION 5.0 OF INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B AS SHOWN ON PAGE 2 OF THIS DSI.

NOTE: ALL INSTALLATION FASTENERS FOR THE ABOVE CHANGES HAVE BEEN UPDATED. SEE THE AMENDED PARTS LIST ON PAGE 2 FOR DETAILS.

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Α	NEW IS	SSUE			AJS	09.02.24
REV.				DESCRIPTION	BY	DATE
DESIGN		Α	JS_	DART AEROSP	ACE	LTD
DRAWN		A	JS	HAWKESBURY, ONTAR	IO, CAN	ADA
CHECKE	D		7	DRAWING NO.		REV. A
MFG. AP	PR.	N.	/ / 2	DSI 9450	_	SHEET 1 OF 3
APPROV	/ED	M	Y	TITLE		SCALE
DE APP	₹.	-	-	ceil SKIDTUBE INSTALLATIONS	3	NTS
DATE	09.0	2.24		COPYRIGHT © 2009 BY DART A THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ACT TO SE USED FOR ANY PURPOSE OR COPIED OF COMPANY WHITTEN PERMISSION FROM DANT A	ON THE EXPRI	ESS CONDITION THAT IT IS

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5.0 PARTS LIST

QTY -011	QTY -012	QTY -013	QTY -014	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
х						D209-669-011	SKIDTUBE INSTALLATION, LH (AH-1W/J)
	х					D209-669-012	SKIDTUBE INSTALLATION, RH (AH-1W/J)
		x				D209-669-013	SKIDTUBE INSTALLATION, LH (AH-1P/F/S)
			х			D209-669-014	SKIDTUBE INSTALLATION, RH (AH-1P/F/S)
1	1			Х		D209-669-041	REPLACEMENT SKIDTUBE (AH-1W/J)
		1	1		X	D209-669-043	REPLACEMENT SKIDTUBE (AH-1P/F/S)
	-011	-011 -012 X	-011 -012 -013 X X	-011 -012 -013 -014 X X X	-011 -012 -013 -014 -041 X X X X X X	-011	-011 -012 -013 -014 -041 -043 PART NUMBER X D209-669-011 X D209-669-012 X D209-669-013 X X D209-669-014 1 1 X D209-669-041

<u>IS:</u>

			· · · · ·	П		
50	4	4	1	1	D3405-041	LUG ASSEMBLY
51	8	8	4	4	AN4C47A	BOLT
52	16	16	8	8	D2570	BUSHING
53	8	8	4	4	MS21043-4	NUT
54			1	1	D3405-043	LUG ASSEMBLY
60	1	1	1	1	D3407-041	TOW RING ASSEMBLY
61	1	1	1	1	D3456-1	WASHER
62	1	1	1	1	MS21043-4	NUT
63	2	2	2	2	D3417-5	WASHER

WAS:

	T	1	Τ	1	TT	
50	4	4	1	1	D2736-1	GHW LUG
51	8	8	4	4	AN4-46A	BOLT
52	16	16	8	8	D2570	BUSHING
53	8	8	4	4	MS21042L4	NUT (OR MS21042-4)
54			1	1	D2736-3	GHW LUG
60	1	1	1	1	D2968-041	TOW RING
61	1	1	1	1	AN970-4	WASHER
62	1	1	1	1	MS21042L4	NUT (OR MS21042-4)

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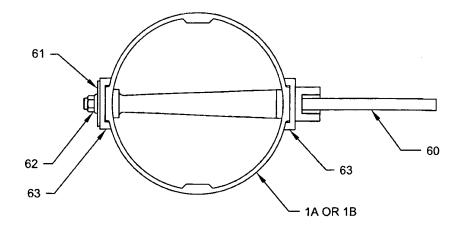
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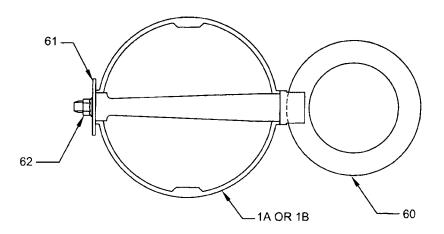
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